

AXILLON AEROSPACE WORK INSTRUCTION

Approved Special Processors List (ASPL)

Company Confidential

Document	QA-SP2-WI-001
Version	33
Date	11 Jun 2026
Function	Quality
Process Owner	Sr Quality Manager

REVISION RECORD SHEET

Version	Date	Description	Approval Status	Training Required (Y/N)
--	15 Jun 1992	Original Issue.	Approved	-
A	01 Aug 1997	Complete Revision.	Approved	-
B	31 Jan 2000	Replace Title Page and Page 9.	Approved	-
C	18 Feb 2000	Replace Title Page, Index of Revision Pg. 3, Effective Pages Sheet 6, Revised Pgs. 6, 7, 10 & 11.	Approved	-
D	06 Apr 2000	Replace Title Page, Index of Revision Pg. 3, Effective Pages Sheet 6 and Revised Pg. 10.	Approved	-
E	24 Aug 2000	Replace Title Page, Index of Revision Pg. 3, Effective Pages Sheet 6 and Revised Pgs. 11.	Approved	-
F	31 Aug 2000	Replace Title Page, Index of Revision Pg. 3, Effective Pages Sheet 6 and Revised Pgs. 10.	Approved	-
G	15 May 2003	Replace Title Page, Index of Revision Pg. 3, Effective Pages Sheet 6 and Revised Pgs. 6, 8 & 9.	Approved	-
H	04 Oct 2004	Replace Title Page, Index of Revision Pg. 3, Effective Pages Sheet 6 and Revised Pgs. 11.	Approved	-
I	17 Jan 2006	Replace Title Page, Index of Revision Pg. 3, Effective Pages Sheet 6 and Revised Pgs. 11 & 12.	Approved	-
J	02 Apr 2008	Complete Revision.	Approved	-
K	10 Aug 2009	Added Approved Suppliers. Complete reformat. Name change.	Approved	-
L	12 Jul 2012	Added Exotic Heat Treat, National Technical Systems, Burrell Enterprises, Missouri Metals & Aerospace Defense Coatings.	Approved	-
M	16 Jan 2013	Added SunGlo as Approved Plater.	Approved	-
N	26 Jul 2013	Amended Section 2.0.	Approved	-
O	03 Oct 2013	Rename Procedure, Add Section 5.0 and renumber subsequent sections, Update Section 1.0, 2.0 & 4.0.	Approved	-
P	04 Mar 2014	Removed SunGlo as Approved Plater (Pg. 8).	Approved	-
Q	15 Sep 2014	Added Dynamic Paint Solutions (Pg. 7). Updated Boeing Approved Processors List.	Approved	-
R	10 Dec 2014	Expanded Dynamic Paint Solutions Processes (Pg. 8).	Approved	-
S	14 May 2015	Updated name change for Dixie Plating Inc. to Freedom Metal Finishing (Pg. 7).	Approved	-
T	03 Jan 2017	Added Special Processors (& Sub-Tier Special Processors) to the list. Heat Treat: Hi TecMetal Group (HTG) Testing: Voss Ind. & Orbit Ind., Inc. Updated Section 2.0 "Applicability" to include applicability to Prime and Government Contracts.	Approved	-
U	10 Feb 2017	Added scope of approval for Voss Industries (FPI), Added Anoplate Corporation Approval for Anodizing (CP).	Approved	-
V	26 Jul 2017	Remove Protect from Sikorsky and LMCO Approved Vendor due to Sikorsky QA Alert.	Approved	-

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W	14 Dec 2017	Document name changed to Approved Special Processors List (ASPL). Added approval of Everett Plating, Inc. (EPI) to Anodizing (CP). Added Dan's Certified Welding, Inc. Approval to Fusion Welding (WLD).	Approved	-
X	18 Jan 2018	Added additional scopes of approval for Everett Plating (AC7108/12 Passivation).	Approved	-
Y	14 Aug 2018	Added additional scope of approval for Everett Plating (AC7108/11, Conversion Coating, MIL-DTL-5541 & MIL-C-5541) 18-125.	Approved	-
26	12 Apr 2022	Reformat and new identification applied for GBMS alignment. QA-202-P is now a WI of QA-P-SP2 making QA-202-P obsolete. Add "Coatings" to Plating Table (Pg. 10), Add Churchill Corporation to Plating/Coatings Approval (Pg. 11) and to Heat Treating Approvals (Pg. 11).	Approved	-
27	07 Jul 2022	Adjust formatting; Remove QA-P-SP2 reference and replaced with MPRC-10; Added Radius Aerospace to Heat Treatment.	Approved	-
28	10 Feb 2023	Added Hixson Metal Finishing to Plating and Coatings under Section 6.0.	Approved	-
29	05 March 2024	Update Section 6 to Add Nadcap expectations.	Approved	-
30	28 Feb 2025	Update formatting to reflect Axillon; Added Shelton to Heat Treatment in Section 6.0; Added Cross Precision Measurement and Fox Valley Metrology Calibration Services in Section 6.0; Supplier name changed from Scale Systems Inc. to System Scale Corporation.	Approved	N
31	16 Jan 2026	Add Phoenix to Approved List for Welding; Removed inactive suppliers from the Plating's /Coatings process table; Added suppliers AMETEK Brookfield, Beckman Coulter, Chroma Systems, Dickson, Electro Rent, Hexagon, and Wabash MPI / Carver to Calibration table; Updated Faro Technologies, Instron, and TA Instruments in Calibration table; Removed Alpha Technology, Brookfield Engineering, Brown & Sharpe, Certified Measurements, ETA of America, GA Dept Agriculture, Hach Company, Industrial Scales of GA, Lumasense, Scientific Atlanta, Southern Gauge, and VIRTEK from Calibration table.	Approved	Y
32	5 May 2026	Complete re-write after split from Fuel Containment. Polymer related special processors removed.	Approved	N
33	11 Jun 2026	Remove QA-SP2-G-02 (LMCO Purchase Order Supplement Codes) from section 9.0.	Approved	N

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1.0 PURPOSE

This Axillon Aerospace procedure defines Axillon Aerospace (Rockmart)'s Special Processes and provides for the establishment and maintenance of sub-tier vendor special process and service system to control processes that have a significant impact on the success or failure of products and subassemblies produced by Axillon Aerospace (Rockmart).

2.0 SCOPE

This Axillon Aerospace procedure is applicable to all identified Axillon Aerospace (Rockmart) Special Processors and any Supplier or Sub-tier Supplier who provides a product or service where the output cannot be verified by subsequent monitoring or measurement and, as a consequence, deficiencies become apparent only after the product is in use or the service has been delivered.

The sources listed are approved to perform only those Special Processes or tests specifically identified in this document. Certain "Prime" contracts may dictate the Suppliers (or Sub-tier Suppliers) who are approved, and the minimum qualifications for approval, to conduct special processes within the scope of their contract. Unless otherwise noted in the "Customer Approval" column of this ASL, no approval is granted, nor applied, unless they are specifically listed in the "Primes" ASL or Axillon Aerospace has expressed written consent from the "Prime" customer for that Supplier or Sub-tier Supplier.

3.0 RESPONSIBILITIES & AUTHORITY

3.1 PROCUREMENT

- Responsible for updating supplier databases, ERP systems and Axillon Aerospace (Rockmart) Approved Supplier List in accordance with purchase order requirements and the requirements outlined herein.

3.2 QUALITY

- Quality Engineering** – Responsible for reviewing customer and regulatory requirements for Special Process Approval authorization and is responsible for maintaining access to current customer approved source listings.
- Quality Systems** – Responsible for the verification of conformance and, upon verification, updating the Approved Special Processors and Process tables within this document.
- Receiving Inspection** – Responsible for verifying at time of receipt that only approved processors were used for processes defined within this document.

4.0 DEFINITIONS AND ABBREVIATIONS

- Special Process** – any production or service process which generates products or services which cannot be measured, monitored or verified prior to delivery and use.
- Special Services** – services performed by laboratories for providing accurate verifiable reports concerning metallurgy, rubber properties, chemical properties, qualification, destructive and non-destructive testing and calibration.
- Approved Supplier List** – a register of the suppliers that are approved to supply Axillon Aerospace for production materials and services, as defined by Axillon Aerospace (Rockmart)'s Quality Management System. The ASL will maintain scope of approval, quality certifications and supplier details.

5.0 PROCEDURE

Axillon Aerospace (Rockmart) has reviewed its production processes to determine if any production or service provision is used where the resulting output cannot be verified by subsequent monitoring or measurement and, as a consequence, deficiencies become apparent only after the product is in use or the service has been delivered.

Processes that are identified as Special Processes will be validated at point of identification and periodically re-validated to ensure that the process is achieving planned results. Re-validation will include, but is not limited to:

- Review of defined criteria for approval of the process
- Approval of equipment and qualification of personnel working within the process
- Use of specific methods and procedures for the process
- Review of records pertaining to the process

The following matrix identifies the Special Processes reviewed by Axillon Aerospace (Rockmart) and their applicability to the requirements of this procedure.

AXILLON AEROSPACE (ROCKMART) SPECIAL PROCESS MATRIX				
KEY:	SP	ST	N/A	
	Identified Axillon Aerospace (Rockmart) Special Process	Special Processes Performed by Sub-Tier Suppliers	Special Processes Not Applicable to Axillon Aerospace (Rockmart)	
SPECIAL PROCESS	SP	ST	N/A	
Chemical Processing (CP)				
Anodizing		X		
Chemical Milling			X	
Chemical Cleaning			X	
Conversion / Phosphate Coating		X		
Etching		X		
Laboratory Evaluation			X	
Paint / Dry Film Coatings	X	X		
Plating		X		
Stripping			X	
Surface Prep Prior to Metal Bond and Surface Treatment / Passivation			X	
Coatings (CT)				
Thermal Spray			X	
Vapor Deposition			X	
Diffusion Coating Process			X	
Stripping of Coated Parts			X	
Coatings Evaluation			X	
Plating of Coated Parts and Heat Treating of Coated Parts			X	
Composites (COMP)				
Prepreg / Adhesive Bonding	X			
Resin Film Infusion			X	
Metal Bonding			X	
Core Processing	X			
Liquid Resin Processing			X	

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Conventional Machining as a Special Process (CMSP)			
Hole Making			X
Turning			X
Grinding			X
Broaching			X
Milling			X
Edge Treatment			X
Elastomer Seals			
O-Ring			X
Plate Seals/Rubber Bonded to Substrates			X
Molded Shapes			X
Compression Seals			X
Compounding			X
Electronics (ETG)			
Printed Boards			X
Circuit Card Assemblies			X
Cable Harness Assemblies			X
Heat Treating (HT)			
Metal Systems			X
Heat Treating Process		X	
Heat Treating Equipment			X
Hot Forming			X
Materials Testing Laboratories (MTL)			
ISO/IEC 17025 Equivalency (AC7006)			X
Chemical Analysis	X	X	
Mechanical Testing	X	X	
Metallography (Micro & Macro)			X
Hardness Corrosion			X
Micro-Hardness			X
Differential Thermal Analysis			X
Fastener Testing			X
Specimen Heat Treating			X
Test Specimen Preparation			X
Nonconventional Machining & Surface Enhancement (NMSE)			
Electrochemical Machining (ECM)			X
Electrochemical Grinding (ECG)			X
Electrical Discharge Machining (EDM)			X
Laser Beam Machining (LBM)			X
Shot Peening			X
Non-Destructive Testing (NDT)			
Magnetic Particle		X	
Liquid Penetrant		X	
Ultrasonic		X	
Radiography (Not a customer requirement, only used as internal inspection method)	X		
Eddy Current		X	

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	Digital Radiography (DDA)			X
Sealants (SLT)				
	Polysulfide			X
	Polythioether			X
	Silicones			X
	Polyurethanes			X
	Adhesive Promoters			X
Welding (WLD)				
	Diffusion Welding			X
	Electron Beam Welding			X
	Flash Welding			X
	Friction / Inertia Welding			X
	Fusion Welding (Including Foundry In-Process / Casting Repair)			X
	Laser Welding			X
	Percussion Stud Welding			X
	Resistance Welding		X	
	Torch / Induction Brazing			X
	Welder / Welding Operator Qualification			X
	Metallographic Evaluation of Welds			X
	Brazing		X	

NOTE: Special Processes that have been determined to be Not Applicable (N/A) to Axillon Aerospace (Rockmart) may still be used but must be evaluated by quality management prior to any work being performed.

6.0 AXILLON AEROSPACE (ROCKMART) APPROVED SUPPLIER SPECIAL PROCESSES

Supplier / Sub-tier purchase orders for materials and services that affect or become part of the end item product and those requiring the vendor to use a special processor and/or service directly or indirectly shall be identified on each purchase order by the use of QA-SP2-G-01 Purchase Order Supplement, Code 79. Sub-tier Vendors listed in the below list of Approved Processors may be 2nd – tier Vendors and are not required to be on Axillon Aerospace (Rockmart)'s Approved Supplier Listing. Control of such special processors will be handled by Axillon Aerospace (Rockmart)'s Direct Suppliers.

Customer Approved Special Processors shall be used when required by Axillon Aerospace (Rockmart) customer contract.

- For Sikorsky product the latest revision of the customer ASL must be used for all “Q” coded processes defined within the latest revision of SS7777 (Material and Process Specifications Index).
- For Bell product the latest revision of the customer ASL must be used for processes defined within Appendix “X” of the Bell SQRM-001.
- For Embraer product the processor must be NADCAP approved for the process being performed.

Processors listed on a “Primes” current ASL may be used even when not listed in this document. The “Primes” ASL shall always take precedent over the processors listed within this document.

Only Nadcap Approved Special Processors will be used for all identified special processes when a Customer Approved Special Processor is required by the Axillon Aerospace (Rockmart) customer contract.

For Axillon designed parts Axillon reserves right to use non NADCAP Approved Special Processors when there is no customer flowdown requiring the use of NADCAP Approved Special Processors.

PLATING / COATINGS / NDT		
COMPANY	PROCESS	APPROVALS
Advanced Aerostructures Inc. Chicopee, MA 01013	PAA - PHOSPHORIC ANODIC COATINGS PRE BOND PER SS8482 B6 - ADHESIVE PRIMER PRE-BOND PER SS8603	Sikorsky
Anoplate Corporation Syracuse, NY 13204	PT - FLUORESCENT PENETRANT, NDT PER SS8806 AII - SULFURIC ANODIC COATING PER SS8483 AIII - HARD COAT ANODIC COATING PER SS8483 CD1 - CADMIUM PLATING	Sikorsky
B & M Painting Camden, AR 71701	AIC - BORIC SULFURIC ANODIC COATING PER SS8483	Sikorsky
Beringer Plating, Inc. Akron, OH 44310	Cadmium Plate Per QQ-P-416, Class 3, Type 1	AXILLON
Churchill Corporation Melrose, MA 02176	Chem Film / MIL-DTL-5541 Type 1, Class 3, Gold	AXILLON APPPROVED FOR S92 CROTCH ONLY
Dynamic Paint Solutions (Valence Eastman) Eastman, GA 31023	B6 ADHESIVE PRIMER PRE-BOND PER SS8603 AIC - BORIC SULFURIC ANODIC COATING PER SS8483 AII - SULFURIC ANODIC COATING PER SS8483 AIIB - THIN FILM SULFURIC ANODIC COATING PER SS8483 MT - MAGNETIC PARTICLE, NDT PER SS8805 PT - FLUORESCENT PENETRANT, NDT PER SS8606	Sikorsky
Freedom Metal Finishing Clearwater, FL 33760	Chem Film per NE 40-006 Anodize per NE 40-030	Embraer via NADCAP Approval
Hixson Metal Finishing Newport Beach, CA 92663	Anodize Per AC7108/08	S92 BARE DUCT ONLY
Metal Finishing Company Wichita, KS 67213	AIC - BORIC SULFURIC ANODIC COATING PER SS8483 AII - SULFURIC ANODIC COATING PER SS8483	Sikorsky
Poly-Metal Finishing, Inc. Springfield, MA 01108	B6 ADHESIVE PRIMER PRE-BOND PER SS8603 AII - SULFURIC ANODIC COATING PER SS8483 AIIB - THIN FILM SULFURIC ANODIC COATING PER SS8483 AIII - HARD COAT ANODIC COATING PER SS8483 PAA PHOSPHORIC ANODIC COATINGS PRE BOND PER SS8482	Sikorsky
Selfridge Plating, Inc. Harrison Township, MI 48045	CD1 - CADMIUM PLATING PER AMS-QQ-P-416	Sikorsky
Valence Surface Technologies Lynnwood, CA 90262	Chem Film per NE 40-006 Chomic Acid Anodize per NE 40-030	Embraer via NADCAP Approval

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HEAT TREATMENT		
COMPANY	PROCESS	APPROVALS
Aerospace Fabrications of GA Dallas, GA 30132	HA1 - HEAT TREAT ALUMINUM ALLOYS INCLUDING 7075T73 HA - HEAT TREAT ALUMINUM ALLOYS EXCLUDING 7075T73 LAB 7 - HARDNESS TESTING LAB 8 - CONDUCTIVITY TESTING	Sikorsky
Braddock Metallurgical Jacksonville, FL	HA1 - HEAT TREAT ALUMINUM ALLOYS INCLUDING 7075T73 HA - HEAT TREAT ALUMINUM ALLOYS EXCLUDING 7075T73 HT1 - HEAT TREAT OF TITANIUM LAB 7 - HARDNESS TESTING LAB 8 - CONDUCTIVITY TESTING	Sikorsky
Churchill Corporation Melrose, MA 02176	Heat Treat/ MIL-H-6088 to T4	AXILLON APPROVED FOR S92 CROTCH ONLY
Missouri Metals St. Louis, MO 63132	HA1 - HEAT TREAT ALUMINUM ALLOYS INCLUDING 7075T73 HA - HEAT TREAT ALUMINUM ALLOYS EXCLUDING 7075T73 HT1 - HEAT TREAT OF TITANIUM LAB 7 - HARDNESS TESTING LAB 8 - CONDUCTIVITY TESTING	Sikorsky
Radius Aerospace – Phoenix Chandler, AZ 85226	AC7102 Accredited: Brazing, Hardness and/or Conductivity Testing, Pyrometry and Heat Treating (Alluminum, Nickle, Cobalt, Stainless Steel & Steel).	S92 BARE DUCT ONLY
Shelton Industrial Pattern Berkeley, MO 63134	HA1 - HEAT TREAT ALUMINUM ALLOYS INCLUDING 7075T73 HA - HEAT TREAT ALUMINUM ALLOYS EXCLUDING 7075T73 LAB 7 - HARDNESS TESTING LAB 8 - CONDUCTIVITY TESTING	Sikorsky

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MATERIAL TESTING / NDT		
COMPANY	PROCESS	APPROVAL
Akron Rubber Development Lab Akron, OH 44301	Testing of Rubberized Raw Materials	Axillon
Applied Technical Services Inc. Marietta, GA 30066	Chemical Mechanical Eddy Current (S92 Inlet Only) Ultrasonic (CH-53K & Bell Parts Only)	Axillon
	MT - MAGNETIC PARTICLE, NDT PT FLUORESCENT PENETRANT, NDT	Sikorsky
B & M Painting Camden, AR 71701	PT - FLUORESCENT PENETRANT, NDT PER SS8806	Sikorsky
Cincinnati Testing Laboratory, Inc. Cincinnati, OH 45202	LAB 9 - COMPOSITE TESTING SIKORSKY MATLS	Sikorsky
Hexpol Compounding, LLC Tallapoosa, GA 30176	Testing of Rubberized Raw Materials	Axillon
Level 3 Associates, LLC Marietta, GA	UT2 - ULTRASONIC NON-METALLIC, NDT PER SS8809	Sikorsky
Metal Finishing Company Wichita, KS 67213	PT - FLUORESCENT PENETRANT, NDT PER SS8806	Sikorsky
NIAR (Wichita State University) Wichita, KS	LAB 9 - COMPOSITE TESTING SIKORSKY MATLS	Sikorsky
Rockmart Fuel Containment Rockmart, GA 30153	Testing of Rubberized Raw Materials	Axillon
Rubber Testing Services, Inc. Akron, OH 44304	Testing of Rubberized Raw Materials	Axillon
Smithers Scientific Services, Inc. Akron, OH 44303	Testing of Rubberized Raw Materials	Axillon
Tygor Labs Milford, CT 06460	Penetrant Inspection per NE 07-001	Embraer via NADCAP Approval
	PT - FLUORESCENT PENETRANT, NDT PER SS8806	Sikorsky
Valence Surface Technologies Lynnwood, CA 90262	Penetrant Inspection per NE 07-001	Embraer via NADCAP Approval
Voss Industries Cleveland, OH	Passivation, Cres A286 & 304 Per AMS2700, Type 6 Fluorescent Penetrant Inspection (FPI) ASTM-E-1417, Type 1, Method A, Level 2	Axillon
Westmoreland Latrobe, PA 15650	LAB 1 - TENSILE TESTING LAB 7 - HARDNESS TESTING LAB 3 - CHEMISTRY TESTING	Sikorsky
	Mechanical Tensile Testing	Axillon

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CALIBRATION SERVICES	
COMPANY	CALIBRATION
AMETEK Brookfield Middleborough, MA 02346	Viscometers (OEM)
Applied Technical Services Marietta, GA 30066	Equipment Calibration (ISO 10012; ISO/IEC 17025:2017)
Atlanta Scales McDonough, GA 30253	Scales (ISO/IEC 17025:2017)
Beckman Coulter Indianapolis, IN 46268	Air Particle Testers (ISO/IEC 17025:2017; OEM)
Chroma Systems Solutions, Inc. Foothill Ranch, CA 92610	Hi-Pot Test Equipment (OEM)
Cross Precision Measurement Greensboro, NC 27410	Equipment Calibration (ISO/IEC 17025:2017)
Dickson Addison, IL, 60101	Temperature and Humidity Recorders and Data Loggers (OEM)
Eisco Labs Honeoye Falls, NY 14472	Pycnometer (OEM)
Electro Rent Corporation Van Nuys, CA	Network Analyzers (ISO/IEC 17025:2017)
Faro Technologies Lake Mary, FL 32746	3D Imaging Calibration (ISO/IEC 17025:2017)
Fox Valley Metrology Oshkosh, WI 54902	Equipment Calibration (ISO/IEC 17025:2017)
Instron Norwood, MA 02062	Instron (ISO/IEC 17025:2017; OEM)
Perkin Elmer Shelton, CT 06484	Fourier Transform Infrared Spectroscopy (FTIR) (OEM)
Simco Electronics Santa Clara, CA 95054	Equipment Calibration (ISO/IEC 17025:2017)
System Scale Corporation Norcross, GA 30093	Scales (ISO/IEC 17025:2017)
TA Instruments New Castle, DE 19720	DMA and DSC (PM & Calibration) (OEM)
Wabash MPI / Carver, Inc. Wabash, IN 46992	Hydraulic Presses, Temperature and Pressure Gauges, Timers (OEM)
3-D Metrology Solutions, LLC Villa Rica, GA 30180	Scanning/Data Collection (Validation Only)

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WELDING / BRAZING		
COMPANY	PROCESS	CUSTOMER APPROVALS
Churchill Corporation Melrose, MA 02176	Braze / MIL-B-7883B	AXILLON APPROVED FOR S92 CROTCH ONLY
Lynn Welding Newington, CT 06111	RW - RESISTANCE WELDING PER AWS D17.2/D17.2M	Sikorsky
Radius Aerospace – Phoenix Chandler, AZ 85226	Fusion Welding STP 55-104, AWS D17.1, STP 55-055 AWS D17.1 (Class B)	Axillon for S92 Duct Only

7.0 RECORDS

The control of Axillon Aerospace procedures shall ensure records are maintained per Axillon Aerospace (Rockmart)'s QA-P-117 Document & Record Control procedure.

8.0 IMPORTANT NOTES

Axillon Aerospace (Rockmart) Special Processes shall remain approved until such time they no longer meet the requirements of this procedure.

Vendors/Suppliers outlined in this ASPL procedure are approved for performance of the Special Processes or Services and shall remain approved until the approval is revoked by Axillon Aerospace (Rockmart).

9.0 REFERENCED DOCUMENTS

- ISO 9001 – Quality Management Systems (QMS) Requirements
- ISO/IEC 17025 – Competence of Testing & Calibration Laboratories Requirements
- ISO 10012 – Measurement Management System Requirements
- SS7777 – Sikorsky Material and Process Specifications Index
- SQRM-001 - Bell Supplier Quality Requirements Manual
- MPRC-10 – Supplier Quality Requirement Document
- QA-SP2-G-01 –Purchase Order Supplement Codes
- QA-P-117 – Document & Record Control

10.0 APPENDICES

N/A